

Work Order ID 48633

June 26, 2009 11:02:40 AM



Page 1

Item ID: D3954-1 **FR**

Accept



Setup Start



Revision ID: A

Stop



Item Name: GWT Pin

Start Date: 15/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Doosan

Doosan Lathe

22/06

Memo

0.00

1-Turn as per folio FA824 & dwg D3954

FOLIO REV: _____

DWG REV: _____

2-Deburr as required



110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00



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Page 2

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: _____

0.00



Memo

0.00

Packaging

160



QC

QC21- Final Inspection - Work Order Release

0.00



Memo

0.00

Quality Control



Picklist Print

June 26, 2009 11:02:40 AM

Page 1

Work Order ID: 48633

Parent Item: D3954-1RevA

Parent Item Name: GWT Pin

Comments:





Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R1.000  303 Round Bar 1.00		Purchased	No			100	f	0.0000	2.4000 			

Date: Wednesday, 17/06/2009 12:50:38 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GWT PIN
Job Number :	48633		
Estimate Number :	13993		
P.O. Number :		Part Number :	D39541
This Issue :	17/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3954 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	48335	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	24/06/2009
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A New Issue JLM 09-06-02 Verified By:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R1000 303 Round Bar 1.00



Comment: Qty.: 0.2415 f(s)/Unit Total: 2.4150 f(s)
 303 Round Bar 1.00
 BATCH: M111571

ml 09/06/22

(10)

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA824 Rev: N/A & Dwg D3954 Rev: A

2-Deburr per dwg D3954

ml 09/06/22

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/06/22

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MA 09/06/22

(10)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 1:40pm
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 2:10pm

ml

09-06-50

(10)

Date: Wednesday, 17/06/2009 12:50:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GWT PIN

Job Number: 48633

Part Number: D39541

Job Number:



Seq. #:

Machine Or Operation:

Description :

MASK AS PER DWG

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 01-06-30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

139C

PC 9/2/01 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



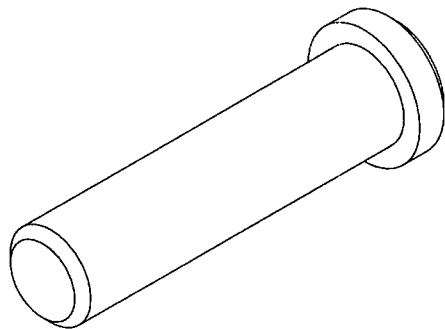
09/07/07

Comment: FINAL INSPECTION/W/O RELEASE

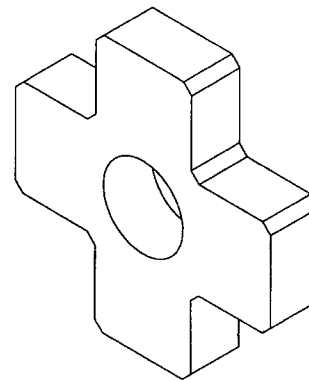
Job Completion



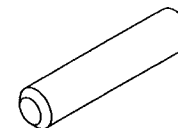
mf
69-07-07



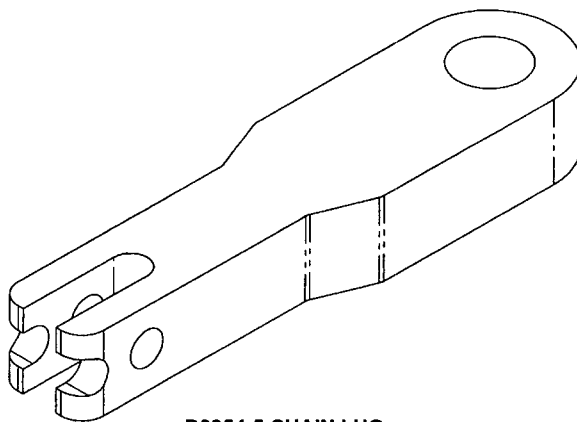
D3954-1 GWT PIN



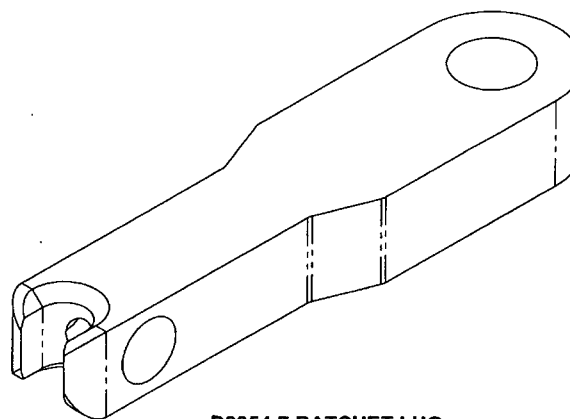
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
04/06/02

48038

A		NEW ISSUE		AJS	09.05.26
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS/DSTOW			DART AEROSPACE LTD	
DRAWN	AJS			HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]			DRAWING NO.	REV. A
MFG. APPR.	[Signature]			D3954	SHEET 1 OF 3
APPROVED	[Signature]			TITLE	SCALE
DE APPR.	N/A			MISC MACHINED PARTS GWT KIT	NTS
DATE	09.05.26			<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

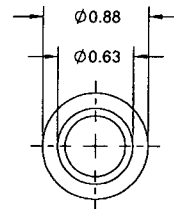
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

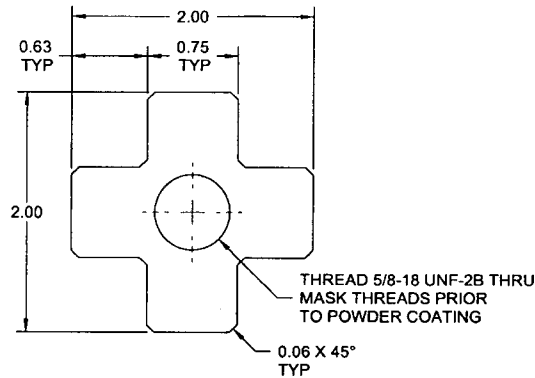
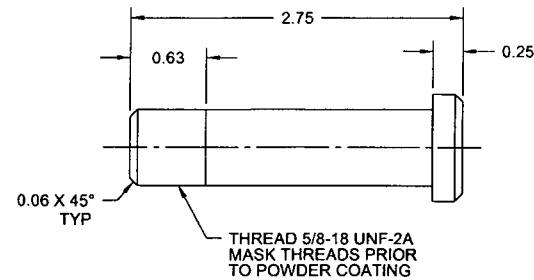
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

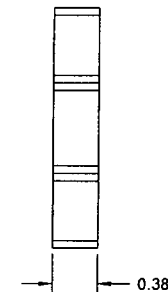
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
PER AMS 5513 OR AMS 5524
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs

RELEASED
09/06/02

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.05.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

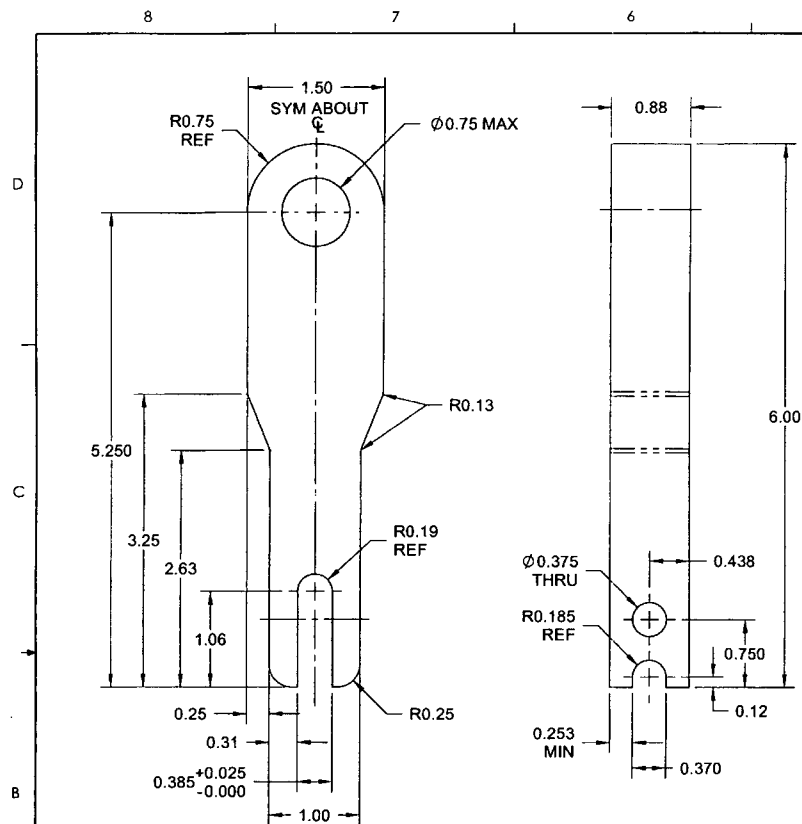
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

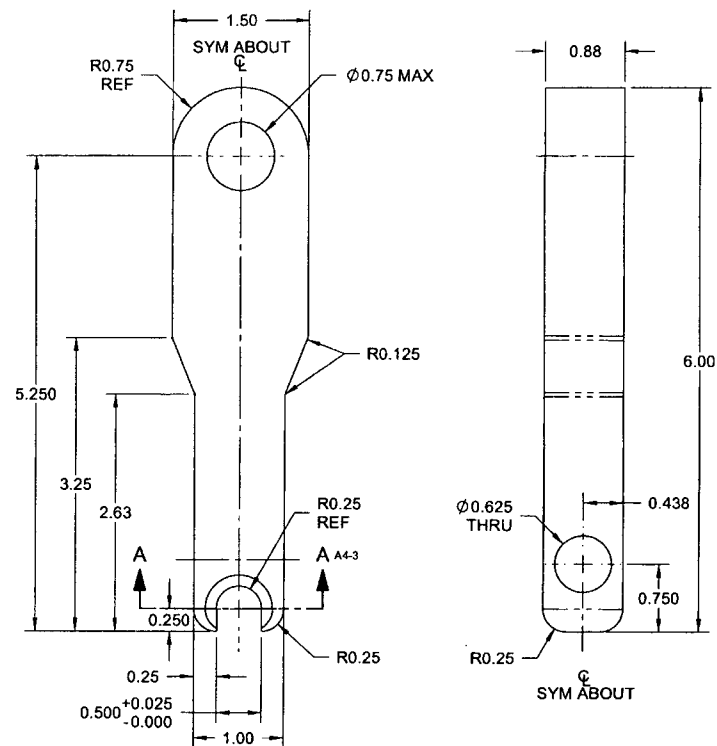
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

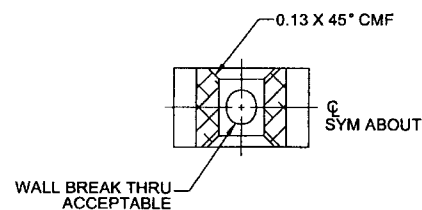
NOTE: Date & initial all entries



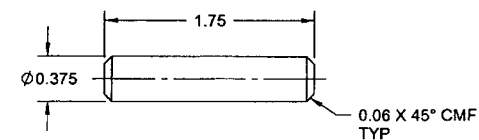
D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



SECTION A-A C3-3



D3954-9 GWT CHAIN PIN



RELEASE
09/06/02 MP

NOTES:

- 1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

- 2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries